

# Work Order ID 71960

Thursday, July 14, 2011 10:34:38 AM



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop



Start Date: 7/14/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

11-07-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100



DOCUMENT CONTROL

0.00

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

8/10/14

for BG 11-8-18 (5)

110



Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

114703  
117884

3-Grind End Plate flush

11.08.12 5  
Ac 11.08.15 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				5	0	BE 11/08/15	
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							5 w/08/15
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							11/08/15



x5 0

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*GB 4/08/16* *(5)*

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 &amp; Dwg D3272

A/R ☐ Aluminum Rod *M114703*

6-Grind End Plate flush

7-Install last rivet as per Dwg.

*PK / Ae 11-08-16*

*11-08-17*

*5* *0*  
*5* *0*

W/O:		WORK ORDER CHANGES					
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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Sub 001/22

RJ

RH

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Sub 003/22

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

SX Ø M-111/08/22  
RH

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

230

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Hand Finishing

Memo

0.00

240

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

5X0 M/L 11/08/22

5X0 M/L 11/08/23

5 BL 11-8-23.

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/8/24

J/S

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S u l o e / 24

+5  
241

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312

Location: Hall

ReoB

11/8/25

J/S

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Reference:

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

n 18/25  
CD 11/08/25

W/O:		WORK ORDER CHANGES					
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Page 1




[illegible]

**STANDARD INFORMATION**

**Required Date:** 7/29/2011

**Required Qty: 5.00**

**Comments:** IPP Rev:A 04.03.22 New issue KJ/RF  
 IPP Rev:B 07-06-09 Added D3572-1 JLM  
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC  
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC IPP Rev:D  
 fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1  Step		Manufactured	No			110	Each	8.0000	1	5		11.08.12	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA	<u>371961</u>			8		5			
					71395			8					
D3067-1  End Plate		Manufactured	No			110	Each	105.0000	1	5		11.08.12	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				84					
					67582			2					
					70700			82					
				WA016				21					
					<u>68214</u>			21		5			
D3219-1  Plate		Manufactured	No			110	Each	96.0000	2	10		11.08.12	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA017				96					
					<u>68338</u>			96		10			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 71960

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 5.00

Required Qty: 5.00

D3066-1 Manufactured No

180 Each 143.0000 2 10



Spacer



Ac 11.08.16

Location

Loc Qty

Loc Code

WA

143

69738

29

70699

114

~~3~~ x3 3+7  
x7

MS20600-AD4W4 Purchased No

180 Each 1,888.000 16 80



Rivets



Ac 11.08.16.

Location

Loc Qty

Loc Code

ST321

1883

116188

59

117364

1000

117601

200

117885

224

118267

400

WA018

5

116712

5

x80

D3065-041 Manufactured No

180 Each 8.0000 1 5



Step Leg Assembly Hi



Ac 11.08.16.

Location

Loc Qty

Loc Code

WA

8

66149

0

69740

8

B70778 x5

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Shop Packet Print

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Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 5.00

Required Qty: 5.00

D3067-1

Manufactured No

180 Each

105.0000 1 5



End Plate

Location

Loc Qty

Loc Code

WA

84

67582

2

70700

82

WA016

21

68214

21

AN3-35A

Purchased No

250 Each

109.0000 2 10



Bolt

Location

Loc Qty

Loc Code

ST353

109

117619

19

117794

50

118112

40

D3235-1

Manufactured No

250 Each

113.0000 2 10



Mounting Lug

Location

Loc Qty

Loc Code

ST471

113

68292

13

69837

100

D3278-041

Manufactured No

250 Each

44.0000 1 5



Support Assembly

Location

Loc Qty

Loc Code

ST471

44

68957

4

69741

40

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Required Date: 7/29/2011

Start Qty: 5.00

Required Qty: 5.00

AN960JD416 NAS1149D0463J Purchased

No

250

Each

0.0000

16

80

Washer

AN960JD516 NAS1149D0563J Purchased

No

250

Each

0.0000

4

20

Washer

AN5-36A Purchased

No

250

Each

93.0000

2

10

Bolt

Location

Loc Qty

Loc Code

ST341

93

117794

43

118012

50

D2618

Manufactured

No

250

Each

177.0000

2

Bushing

Location

Loc Qty

Loc Code

ST019

177

70702

73

71600

104

D2230-3

Manufactured

No

250

Each

218.0000

4

20

Lug

Location

Loc Qty

Loc Code

ST

94

70694

94

ST476

4

53881

4

ST480

120

70973

120

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Start Date: 7/14/2011

Required Date: 7/29/2011

Start Qty: 5.00

Required Qty: 5.00

D2856-400

Manufactured No

250 f

82.7896 1.2 6



Abraison Strip



*[Handwritten signature]*

Location

Loc Qty

Loc Code

ST403

82.12

68076

82.12

ST409

0.6696

63735

0.6696

*[Handwritten checkmark]*

cut (2) D2856-400-720 as per dwg

MS21042L3

Purchased No

250 Each

1,666.000 2



Nut



*[Handwritten signature]*

Location

Loc Qty

Loc Code

ST300

1666

116549

28

117441

800

117601

400

117885

438

*[Handwritten signature]*

AN4-13A

Purchased No

250 Each

666.0000 8



Bolt



40

*[Handwritten signature]*

Location

Loc Qty

Loc Code

ST357

666

117962

72

118078

594

*[Handwritten signature]*

W/O:		WORK ORDER CHANGES					
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Required Date: 7/29/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L5

Purchased

No

250

Each

1,388.000

2

10

Nut

Location

Loc Qty

Loc Code

ST300

1388

116105

5

116548

199

117441

498

117591

100

117611

90

118179

496

MS21042L4

Purchased

No

250

Each

4,043.000

8

40

Nut

Location

Loc Qty

Loc Code

ST300

4043

117441

1796

117601

747

117885

1500

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

20

Washer

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>JB</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *JB*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

△  
B

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *71960*

*11-07-14*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

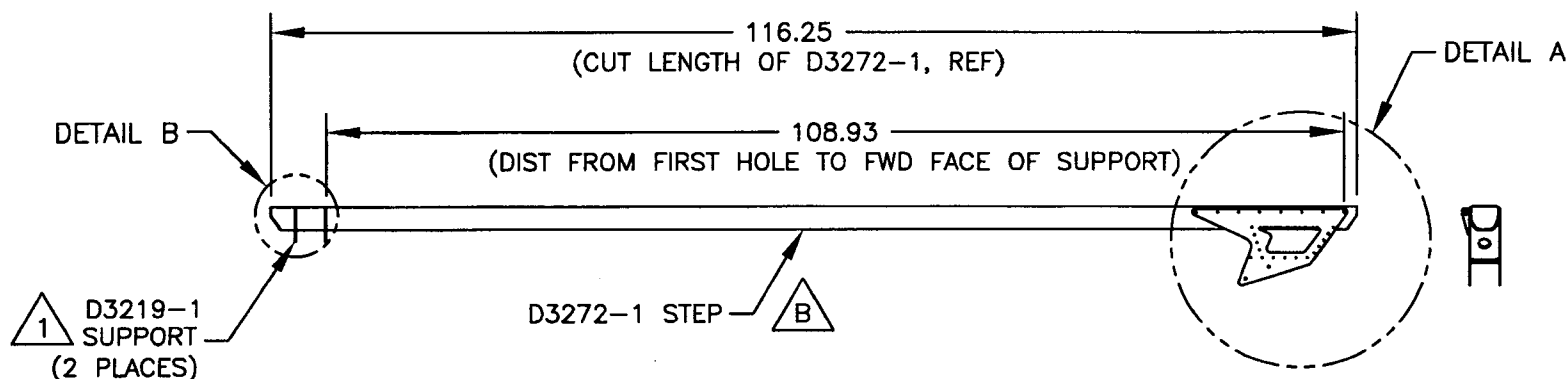
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

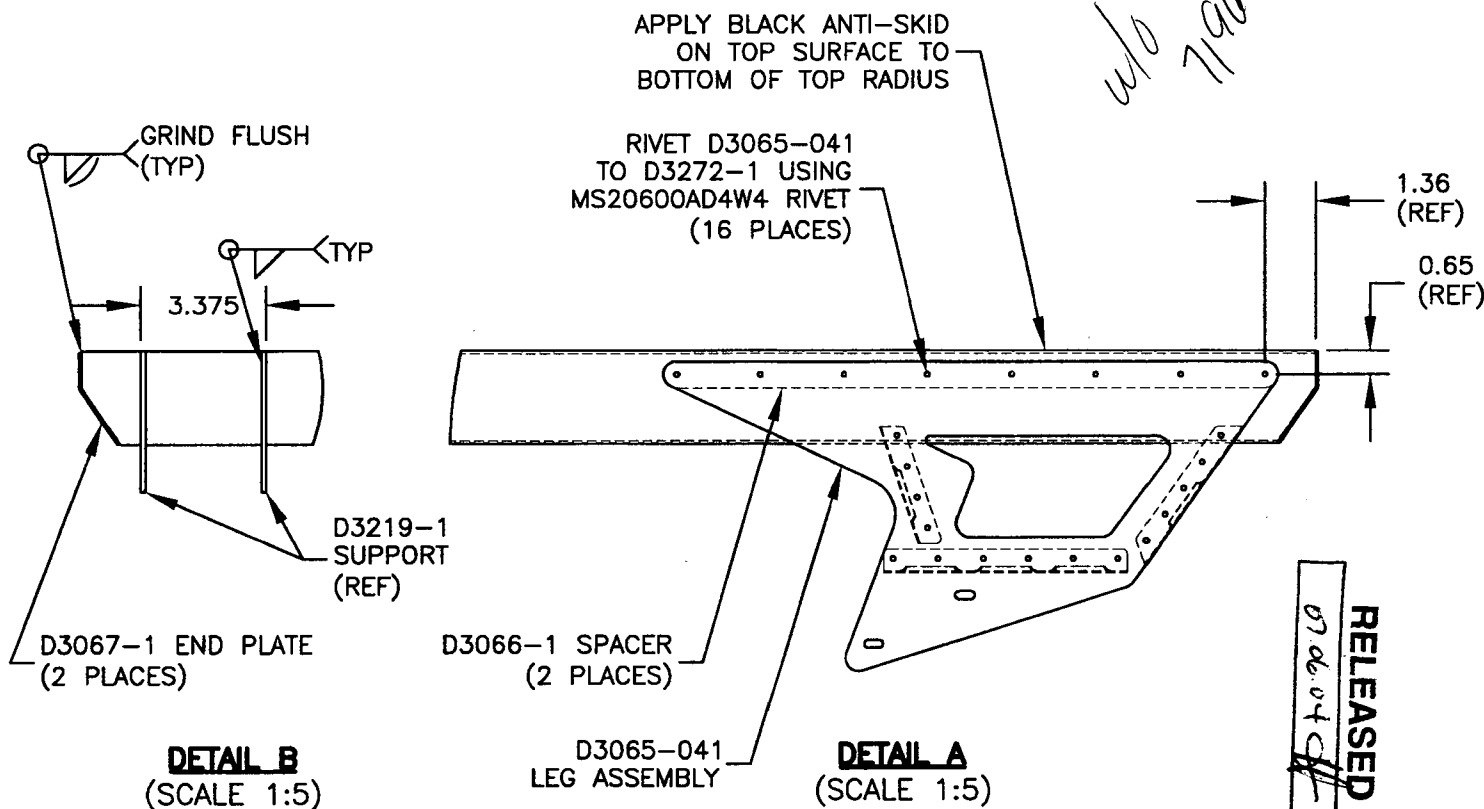
**NOTE:** Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	SHEET 2 OF 3	SCALE 1:20



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

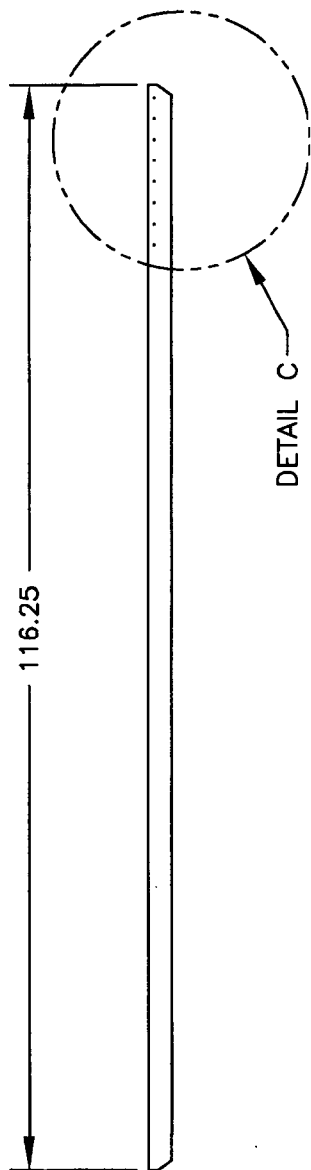
**NOTE:** Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

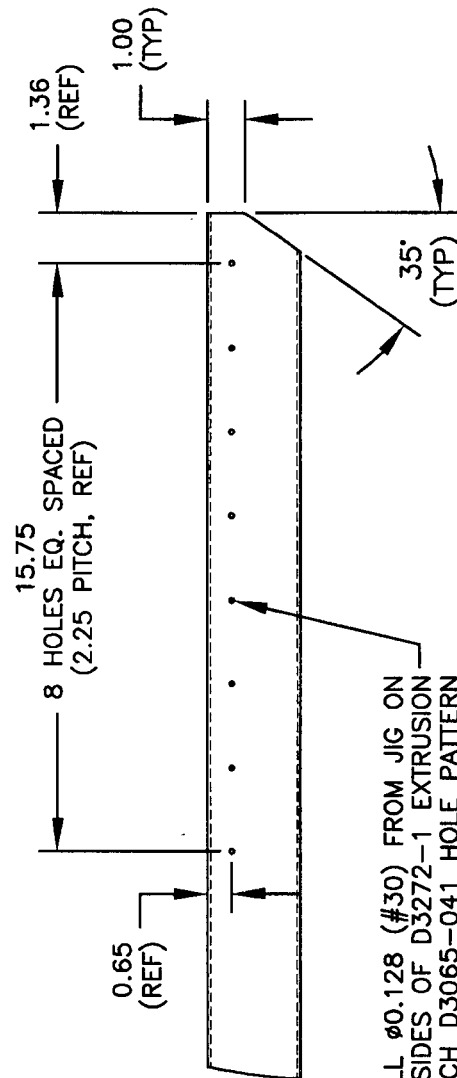
07.06.04 *[Signature]*



DETAIL C

*92611 g/m*

**B** **D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\phi 0.128$  (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.